



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2144**Job Sheet 183853****Part No:** D2144**Job Qty:** 5 ea**Part Name:** Hinge Doubler**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/27/18**Job Tracking No:****Due Date:** 10/5/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:****Note:** DWG REV D IPP: D 04.05.06 Reformat KJ/RF IPP Rev:E Now on Waterjet 06-10-15 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	5 pcs		10/5/18	0.00	0.28	Waterjet 1		SC 18/09/19
110	QC	5 pcs		10/5/18	0.00	0.00	QC2 Waterjet-1		SC 18/09/19
120	QC	5 pcs		10/5/18	0.00	0.00	QC8-1		38
130	Small Fab	5 pcs		10/5/18	0.00	0.19	Small Fab-1		3-89
140	Brake NC	5 pcs		10/5/18	0.01	0.34	Brake NC 2		DAS 40
150	QC	5 pcs		10/5/18	0.00	0.00	QC5		9
160	Large Fab	5 pcs		10/5/18	0.00	0.90	Large Fab 1		1882
170	QC	5 pcs		10/5/18	0.00	0.00	QC9	DAS 24	9-89
180	QC	5 pcs		10/5/18	0.00	0.00	QC5		9-89
190	Powdercoat	5 pcs		10/5/18	0.00	0.09	Powdercoat1		SC 19/02/19
200	QC	5 pcs		10/5/18	0.00	0.00	QC3		SC 19/02/19
210	Packaging	5 pcs		10/5/18	0.00	0.00	Packaging3-1	5002	SC 19/02/19
220	QC21-SA	5 Ea		10/5/18	0.00	0.00	QC21		DAS 21

Part Op 100 - 1-Cut as per Dwg D2144

Descriptions: 130 - Deburr if necessary

140 - Form as per Dwg D2144 Rev: _____

160 - 1- Weld corner as per Dwg D2144 & QSI 004 2- Grind flush

190 - START TIME: 9:00 FINISH TIME: 9:30 WTB 400 - M 138927

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.4725 sf (.0945 ea)	100-Waterjet	5106178

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S16GA	0	274	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

1210 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S114683



Part: D2144

Job No: 183853

Serial No/Batch: S114683

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/29/18

FEB 3 8 3018

FEB 3 8 3018

20 180301

0-88

40

DVS

0-88

40

DVS

180302

DART AEROSPACE LTD		Work Order: 183853
Description: Hinge Bracket		Part Number: D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.380	1		VSC-01	
3.022	+/-0.010	3.020	1			
2.468	+/-0.010	2.470	1			
1.913	+/-0.010	1.915	1			
1.555	+/-0.010	1.557	1			
4.126	+/-0.010	4.125	1			
3.465	+/-0.010	3.468	1			
0.340	+/-0.010	0.340	1			
0.625	+/-0.010	0.625	1			
1.000	+/-0.010	1.001	1			
1.083	+/-0.010	1.085	1			
1.660	+/-0.010	1.660	1			
2.312	+/-0.010	2.315	1			
2.844	+/-0.010	2.845	1			
3.294	+/-0.010	3.295	1			
Ø0.257	+0.006/-0.001	Ø0.258	1			
Ø0.171	+0.005/-0.001	Ø0.172	1			
Ø0.320	+0.006/-0.001	Ø0.322	1			
0.354	+/-0.010	0.355	1			
0.063	+/-0.010	0.057	1			

Measured by: SC	Audited by: DAL 38	Prototype Approval:	N/A
Date: 18/09/29	Date: OCT 01 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	